

Work Order ID 143464

143464

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Tuesday, March 15, 2016 12:41:46 PM

Item ID: D4542-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner, LH
 Start Date: 3/31/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: **MAR 15 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4542	F								
100		0.00							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1- Cut as per dwg								
	Prog rev: <u>F</u>								
	Dwg rev: <u>F</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(8)

PC 16/04/06

(8)

PC 16/04/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>48</u>			DAS 16 9-89 166466
124 *124* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.01				<u>8</u>	<u>1</u>	<u>10</u>	<u>12/04/25</u>
127 *127* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				<u>8</u>			DAS 38 9-89

APR 26 2016

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				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location Sto 28	0.00				8	9.89		
130									
Packaging	Memo	0.00							MAY 06 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01					9.19		16/5/19
Quality Control									MAY 06 2016

20160506

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐ _____					

Picklist Print

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Work Order ID: 143464

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Parent Item: D4542-1

D4542-1

Parent Item Name: Retainer, Inner, LH

Start Date: 3/31/2016

Required Date: 4/8/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP
 REV:B 12.02.24 as per dwg reva DD verf:EC IPP REV:C
 12.05.08 as per dwg revB DD verf:EC IPP REV:D 13.04.23 as
 per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	229.5668	0.833	7.014737			

M6061T6S 0.32

6061-T6 Sheet 0.032"

02/16/09/06

Location

Loc Qty

Loc Code

MAT021

229.56675

m131352

53.6

m132772

39.995

m133757

135.97175

7.0

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		OTHER : ☐							

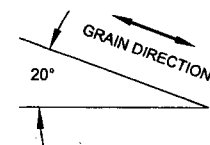
RELEASED
2015-07-05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143464 ML5
1603-15

D4542-1 RETAINER, LH INNER
(LOWER)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-1-REV.F.DXF"



F	UPDATE D4542-5	MB	14.04.10
E	-1 AND -2 NUTPLATE HOLES ELIMINATED. SHT 4 ZONE C7 2.87 DIM WAS 2.70, ZONE C5 10.32 DIM WAS 10.01 (0.20" OF MATERIAL ADDED TO BOTH ENDS OF THE PART FOR TRIM ON INTSL).	AJS	14.03.17
D	RMV HOLES & ADD FINISH FOR -3/-7	CP	13.02.04
C	CORRECT (MIRROR) HOLE LOC. ON -7 (ZN C3-5)	CP	12.07.12
B	RMV FINISH & ADD HOLES (-1/-2/-3/-5/-7) ADD/MODIFY ORIENTATION MARK (C2-4, C5-6)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D4542	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	14.04.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	